Quality Control

											DQA:	Date:					
NCR:	Yes	/ No				WORK ORDER NON-	COI	<b>NFORM</b>	/ANCE / UP	DATE							
											QA Closed:	Date:					
Work Ord	or.					DISPOSITION		AGAINST DEPARTMENT/PROCESS									
work order.						Rework		Skid-tube	Crosstube	1	Water Jet	Engineering					
Part	No.					Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality				
				Use-as-is	1		noforming	Finishing	4	re/Packaging	Other						
NCR No.				Work Order Update			Large Fab	Composite	]	Supplier							
Root						ption of work order update	1	Initial		ction	Sign &						
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector				
Doc/Data																	
Equip/Tooling																	
Operator																	
Material	L																
Setup																	
Other									ļ								
Process			İ														
Supplier																	
Training																	
Unapproved																	
						<u> </u>	FAUL	LT CATE	GORY								
Land	ing (	Gear				General	_	_			_	_	7				
		Bending				Bend		Grain			Ovalized		Pressure/Forced				
	L	Centre N	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Unde	r tolerance	Temperature/Cure				
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ect	Weld				
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete,	/Unclear	Part Lost/M	lissing	Wrong Stock Pulled				
		Cuffs				Contamination		Mainte	nance		Part Moved	i					
		Heat Trea	at			Countersink		Mislabe	led		Positioned	Wrong					
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss	/Surge	Other				

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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Page 2

October-07-13 9:02:38 AM

Item ID: D3912-041

Accept

\*N900040100\*

Setup Start

**Revision ID:** 

Item Name: Eyebolt Receiver Assy

Start:Date: 10/07/13 Required Date: 10/07/13

Start Qty: 3.00

**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:

Process Plan:

Operation

QC:

Req'd Qty: 3.00

Date:

Date: \_\_\_\_\_

**Tooling:** 

**SPC (Y/N):** 

Date: Date: Run

Stop

Sequence ID/ Work Center ID

Description Identify as per dwg & Stock Location: 57072

Set Up/ **Run Hours** 

Tool # Plan Code

Accept Qty

Reject **Qty** 

Reject Insp. Number Stamp

170

\*170\*

Packaging Packaging

Memo

0.00

0.00

3x 28 13-10-24

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

Rm 13/10/29.

MF
13-10-25

											DQA:	Date	:
NCR:	Yes	/ No					WORK ORDER NON-C		VFOR	MANCE / UPDATE			
											QA Closed:	Date	:
Nork Ord	er:						DISPOSITION						
	Part No.						Rework Scrap Use-as-is		1	Skid-tube Crosstube  Machining Small Fab  noforming Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No.						Work Order Update			Large Fab Composite		Supplier		
Root					Desc	crip	ntion of work order update	ı	nitial	Action	Sign &		
Cause		Date	Step	Qty		O	r Non-conformance	Ch	ief Eng	Description	Date	Verification	QC Inspector
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quip/Tooling													
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etup													
ther													
rocess	L							1		with			
upplier	L							ļ					
raining											·		
napproved										<u> </u>			
							. F/	AUL	T CATE	GORY			
Landi	ng (	Gear			-		General		. #			_	_
		Bending					Bend		Grain		Ovalized	L	Pressure/Forced
	L	Centre No	ot Concer	ntric to	O/S		BOM/Route .		Hardwa	re	Over/Under	tolerance	Temperature/Cure
		Cracks			l		Broken/Damaged	L	Inspect	ion Incomplete	Part Incorre	ct	Weld
		Crushed/0	Crimped,				Burrs		Instruct	tions Incomplete/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	L	Cuffs					Contamination		Mainte	enance	Part Moved		
	L	Heat Trea	t				Countersink		Mislabe	eled	Positioned \	Wrong	
		Inspection	n Strip in	Tube	. [		Cut Too Short		Misread	d [	Power Loss/	'Surge	Other
		Ripples in	Bend				Drill Holes		Offset				
		Torque W	aves in E	xtrusio	n [		Drawing		Out of	Calibration			
	Turning Sequence					Finish		Out of	Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

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October-07-13 9:02:37 AM

Work Order ID:

107932

Parent Item:

D3912-041

Parent Item Name:

Eyebolt Receiver Assy

Start Date: 10/07/13

Required Date: 10/07/13

Start Qty: 3.00

Required Qty: 3.00

**Comments:** 

IPP RevA: new issue DD 09.11.18 verified by:EC

IPP Rev:B 10.06.10 memo in

seq110 \*\*\*IF PLUNGER GOES IN TO DEEP, INSTALL A WASHER (AN960C516L) IF

NECESSARY BETWEEN PLUNGER AND D3912-1. YOU MAY HAVE TO ENLARGE WASHER

HOLE FOR IT TO FIT\*\*\* DD verf:JLM

IPP REV:C AS PER REV B 10-08-05 JLM

VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status DAS
NAS1149C0663R Washer		Purchased	No				Each	274.0000		3	13/	10/24	/ 36 9-89
				<b>Location</b>		Loc Qty	<u>Lo</u>	oc Code			, /		
				ST292		274							
				110	5893	24			·				
				m1	25807	50				3			
				m1	26221	200						//	DAS
D3912-1		Manufactured	No			100	Each	36.0000	1	3	/2	/10 /2 /	<b>. 36</b>
Eyebolt											/_	10 /24	9-89
				Location		Loc Qty	<u>L</u> c	oc Code					
				ST144		36							
					)274	3							
				102	2760	24			_3				
					3884	7							040
				770	073	2						11	DAS 36
D3912-3 Eyebolt Block		Manufactured	No			100	Each	40.0000	2	6	13/1	0/4	9-89
				Location		Loc Qty	Lo	oc Code			/ /	<i>'</i>	
				ST144		40							
					2823	14					٠.		
				103	3481	1							
				100	5708	16				<u></u>			
				882		7						x*	
				918	365	2							

											DQA:	Date:					
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPI	DATE							
											QA Closed:	Date:					
Work Ord	er.					DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Part No.  NCR No.						Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other					
Root					Descri	ription of work order update   Initial   Action				tion	Sign &						
Cause		Date	Step	Qty	. (	or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector				
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved																	
					·		AUI	LT CATE	GORY								
Landi		Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube				General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread			Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled				
	-	Ripples in				Drill Holes		Offset		L	J	~ <b>L</b>	<u> </u>				

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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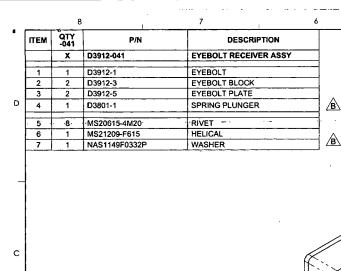
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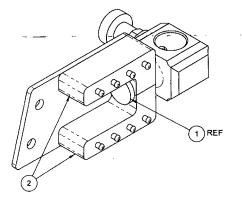
	Work Order ID: Parent Item:	107932 D3912-041							Ston	t Date: 10/07/13		Required Date: 10/07/13	1 - -
*	Parent Item Name:	Eyebolt Receiver Ass	sy							rt Qty: 3.00		Required Qty; 3.00	DAS
* **	D3912-5 Eyebolt Plate		Manufactured	No			100	Each	24.0000	2	6	13/10/24	36 9-89
					Location	<u>1</u>	Loc Qty		Loc Code			/ /	
2. 2.	•				ST144		24						
ş						102939	22			6_			
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À	D3801-1		Manufactured	No				Each	18.0000		3	12/12/14	36 9-89
	Hand Retractable Spring	Plunger									·		
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3					GA		10						
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					ST066		8					,	
						106795	8						DAS 36 9-89
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	Rivet												
					Location	<u>n</u>	Loc Qty		Loc Code				2 -
	r				GA		83			-			
						125567	83			$\propto 4$			DAS
	MS21209-F615		Purchased	No				Each	62.0000		3	17/10/21	36
	Heli <sup>*</sup> Coil											1)/0/0/4-	9 89
					Locatio	<u>n</u>	Loc Qty		Loc Code				7 7
					GA		62						
2.4						121561	2			<del></del>			
i.						125097	60						

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

						<u>,</u>			QA Closed:	Date	•				
Work Orde	r:				DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part No					Rework Scrap Use-as-is Work Order Update	4 1	Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite	Pro Rec/Sto	Engineering Quality Other					
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &						
Cause	Date	Step	Qty	,	or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector				
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other										•					
Process	_														
Supplier	┥ .														
Training			]												
Unapproved		1				ALU T CAT	CORY		<u> </u>						
1						AULT CATI	GORY								
Landin					General	Casia			10	¬					
-	Bending Centre No	nt Canaca		o/s	Bend BOM/Route	Grain		<u> </u>	Ovalized		Pressure/Forced				
-	Cracks	ot concer	itric to	<sup>0/3</sup>  -	Broken/Damaged	<del></del>			Over/Under Part Incorre	<b> </b>	Temperature/Cure Weld				
-	Crushed/	Crimpod		-	Burrs	<b>—</b>	tion Incomplete	/Unclose	Part Incorre	<b>⊢</b>	<del></del>				
-	Cuffs	Crimpeu.		-	Contamination	<b>—</b>	tions Incomplete/ enance	Unclear	Part Moved		Wrong Stock Pulled				
}	Heat Trea	at .			Countersink	Mislab			Positioned \						
}	Inspection		Tuhe	-	Cut Too Short	Misrea		-	Power Loss/		Other				
<b> </b>	Ripples in	•	TUDE	<b>—</b>	Drill Holes	Offset		<u> </u>	Trower ross/	Juige	Tottlet				
<u> </u>	Torque W		xtrusio	n  -	Drawing	<b>⊢</b>	Calibration								
-				·	Finish	$\vdash$	Sequence								
F	Turning Sequence Wave/Twist in Tube				Folio	$\vdash$	e Dimensions			<u> </u>					

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SUPPLEMENTAL ISO VIEW (EYEBOLT PLATE REMOVED TO SHOW INTERIOR FEATURES)

107932 MU 13-10-09

## **D3912-041 EYEBOLT RECEIVER ASSY**

5 ) 8X

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING
FINE POINT PERMANENT INK MARKER

D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1. 10.08.28 NEW ISSUE 10.03.04 JPH DESCRIPTION REV. BY DATE

DESIGN DRAWN DRAWING NO. CHECKED D3912 MFG. APPR TITLE APPROVED DE APPR. DATE

10.06.28

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA

REV. B SHEET 1 OF 3 SCALE NTS

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TO PRIVATE MID CONFIDENTIAL AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS
TO FOR MIN PURPOSE OR COMED OR COMMANICATED TO MIN OTHER PERSON WITHOUT

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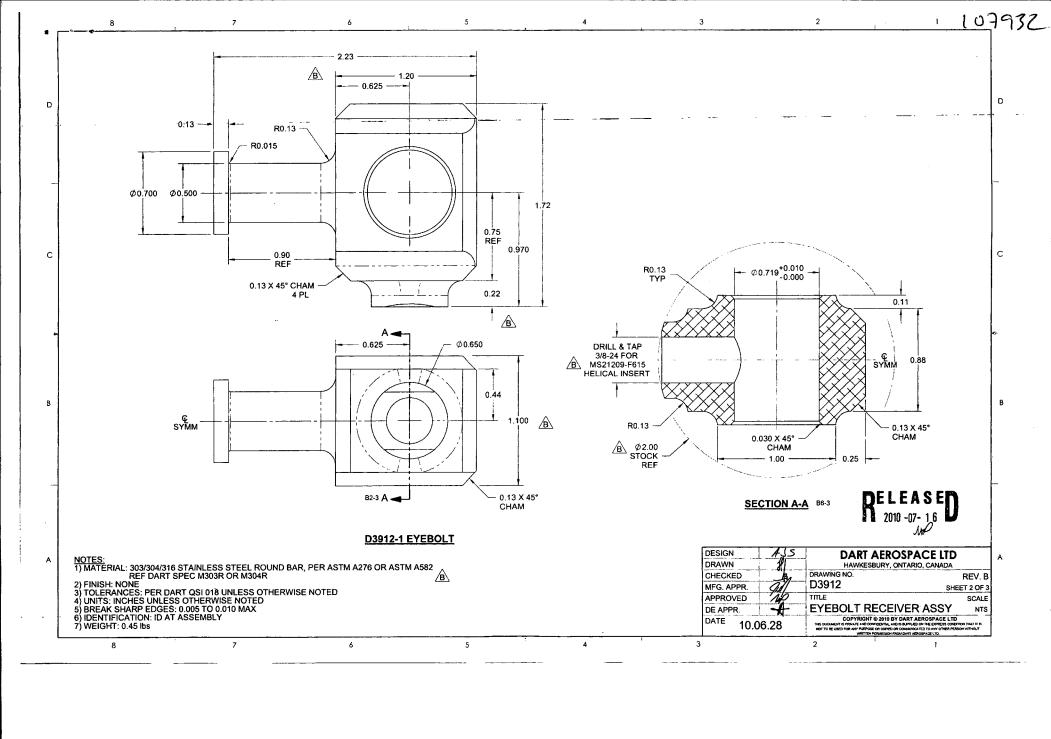
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**EYEBOLT RECEIVER ASSY** 



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107937 D 3.15 1.500 0.800+0.000 2.30 0.500 PITCH R0.13 TYP Ø0.129 THRU -- 0.38 1.500 4 PL 0.400 0.500 PITCH С 0.25 0.517 0.50 REF 1.00 0.750 +0.000 -0.020 1.000 1.500+0.020 0.500 R0.13 2.00 R0.125 TYP 0.516+0.015 0.63 105° REF Ø0.129 Ø0.257 8 PL 0.125 2 PL REF **D3912-3 EYEBOLT BLOCK** 3.65 В 3.69 REF **D3912-5 EYEBOLT PLATE** NOTES: 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M303B OR M304B -5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 REF DART SPEC M303S11GA OR M304S11GA DESIGN DART AEROSPACE LTD Α 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3912 MFG. APPR SHEET 3 OF 3 TITLE APPROVED SCALE DE APPR **EYEBOLT RECEIVER ASSY** NTS COPYRIGHT @ 2010 BY DART AEROSPACE LTD HIS DOCUMENT OF STATE AND CONSTRUCTION AND SEPTED ON THE DOCUMENT OF TH DATE 10.06.28